

Date: Thursday, 3/16/2006 10:38:38 AM  
 User: Kim Johnston

## Process Sheet

|                       |                                       |                  |                             |
|-----------------------|---------------------------------------|------------------|-----------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : TUBE                      |
| Job Number            | : 26286 <i>ADH</i>                    |                  |                             |
| Estimate Number       | : 12168                               | Part Number      | : D34783                    |
| P.O. Number           | : N/A                                 | Drawing Number   | : D3478 REV A               |
| This Issue            | : 3/16/2006 S.O. No. : N/A            | Project Number   | : N/A                       |
| Prsht Rev.            | : NC                                  | Drawing Revision | : A                         |
| First Issue           | : N/A Type : SMALL /MED FAB           | Material         | : N/A                       |
| Previous Run          | : N/A                                 | Due Date         | : 3/31/2006 Qty: 1 Um: Each |
| Written By            | : <i>SEE COMMENT BELOW</i>            |                  |                             |
| Checked & Approved By | : <i>06.03.16</i>                     |                  |                             |
| Comment               | : Est Rev: A New Issue 06-02-03 JLM   |                  |                             |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                     |
|-----|-----------|---------------------|
| 1.0 | M304S26GA | 304/316 0.018 SHEET |
|-----|-----------|---------------------|



Comment: Qty.: 0.1545 sf(s)/Unit Total : 0.1545 sf(s)

Pick:

304/316 0.018 SHEET

(M304S26GA)

Batch: *M19704*
*AB 060328 ①*

|     |       |       |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR

Cut Flat pattern 2.00" X 8.79" as per Dwg D3475

*AB 060328 ①*

|     |             |                               |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3478

3-Form Bead as per Dwg D3478 Using Rotary Machine.

4-Spot Weld as per Dwg D3478 and Dart QSI 018

5-Cut 69 Deg Angle as per Dwg D3478.

*AB 060328 ①*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/30

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 26286

Part Number: D34783

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.03.29

①

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

06.03.29

①

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

06.03.30

①

Job Completion



06.03.29

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

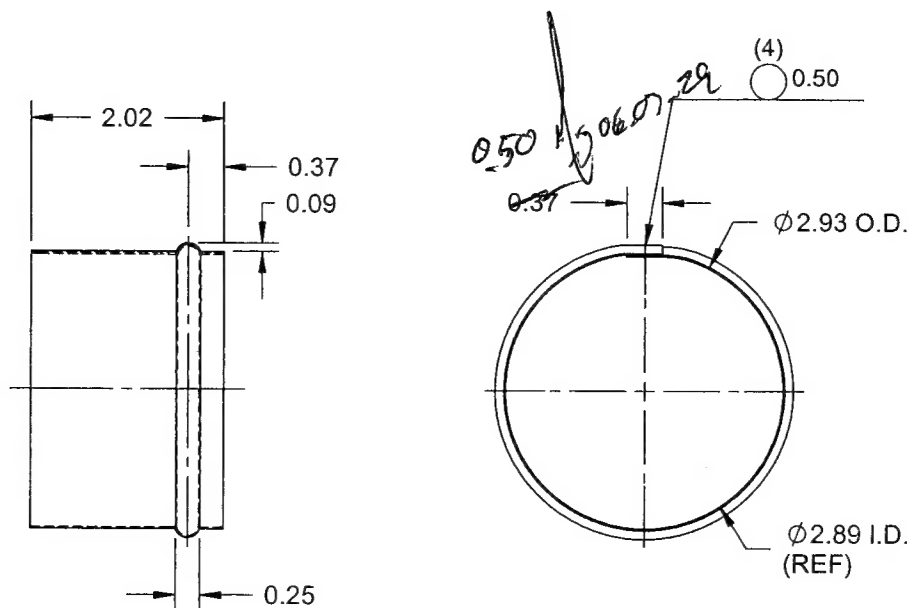
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

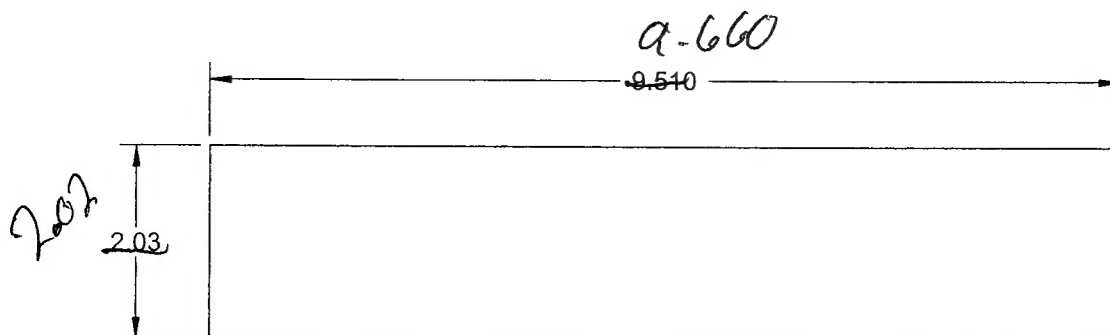
**NOTE:** Date & initial all entries

PRELIMINARY ISSUE

|  |  |   |                        |
|--|--|---|------------------------|
| DESIGN<br> | DRAWN BY<br> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED  | APPROVED   | DRAWING NO.<br>D3478                              | REV. A<br>SHEET 3 OF 3 |
| DATE<br>05.12.08   |  | TITLE<br>AIR INLET ADAPTER                        | SCALE<br>1:2           |



**D3478-3 TUBE**



**D3478-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 018
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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